

206628024

Dart Aerospace Ltd.

Date: Thursday, 5/10/2007 2:29:26 PM
User: Kim Johnston

Process Sheet

shp 28/06

SPV 20621

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY (206/407)
 Job Number : 32254A - 1-2
 Estimate Number : 11775
 P.O. Number : N/A
 This Issue : 5/10/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 31239A
 Written By :
 Checked & Approved By : J. 07.05.10
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Part Number : D2842042
 Drawing Number : D2842 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 5/30/2007 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion B31984

Check Material for any Dents or Defects

Handwritten signature and date: 07.06.19

4

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

Handwritten signature and date: 07.06.19

4

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

Handwritten signature and date: 07.06.19

4

3-Deburr and bevel ends for welding

Handwritten signature and date: 07.06.19

4

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch:
 2 D2734 End Cap B30283

Handwritten signature and date: 07.06.19

4

4.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

plate

Batch: B30909 = 4 B32292

Handwritten signature and date: 07.06.19

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:09:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: 331238

PE 07-06-19 3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842

A/R AL Rod Batch: M102756
M104305

2-Grind end cap weld flush

PE 07-06-20 3
FF 07-06-20 3

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

QC5 6/20/06-20 (4)
QC9/10 07-06-20 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Er 07-06-21 (x3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-06-21 (3)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M102756

2-Grind end cap weld flush.

Q.M 07-06-21

PE 07-06-21 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-21	8.0	Split into for Qty 1 on split - 2 & Qty 3 on this W.O.	[Signature]	07-06-21	3	[Signature] 07-06-21	[Signature] 07-06-21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:09:26 PM
User: Kim Johnston

Process Sheet

RH

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LIT (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/21 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/21 (3)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M104144 BR/M/L

(3)

07-06-25

14.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M102974

15.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M19522

16.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

M1104603

17.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M102473

07-06-25 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:09:26 PM
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Process Sheet

RH

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M104733

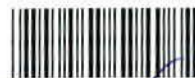
HP 07-06-25 (3)

HP 07-06-25 (3)

19.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

P 7/7/03 (2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP B32254 P 7/7/3

21.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/07/04

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**DART AEROSPACE USA, INC.**
PORT HADLOCK, WA

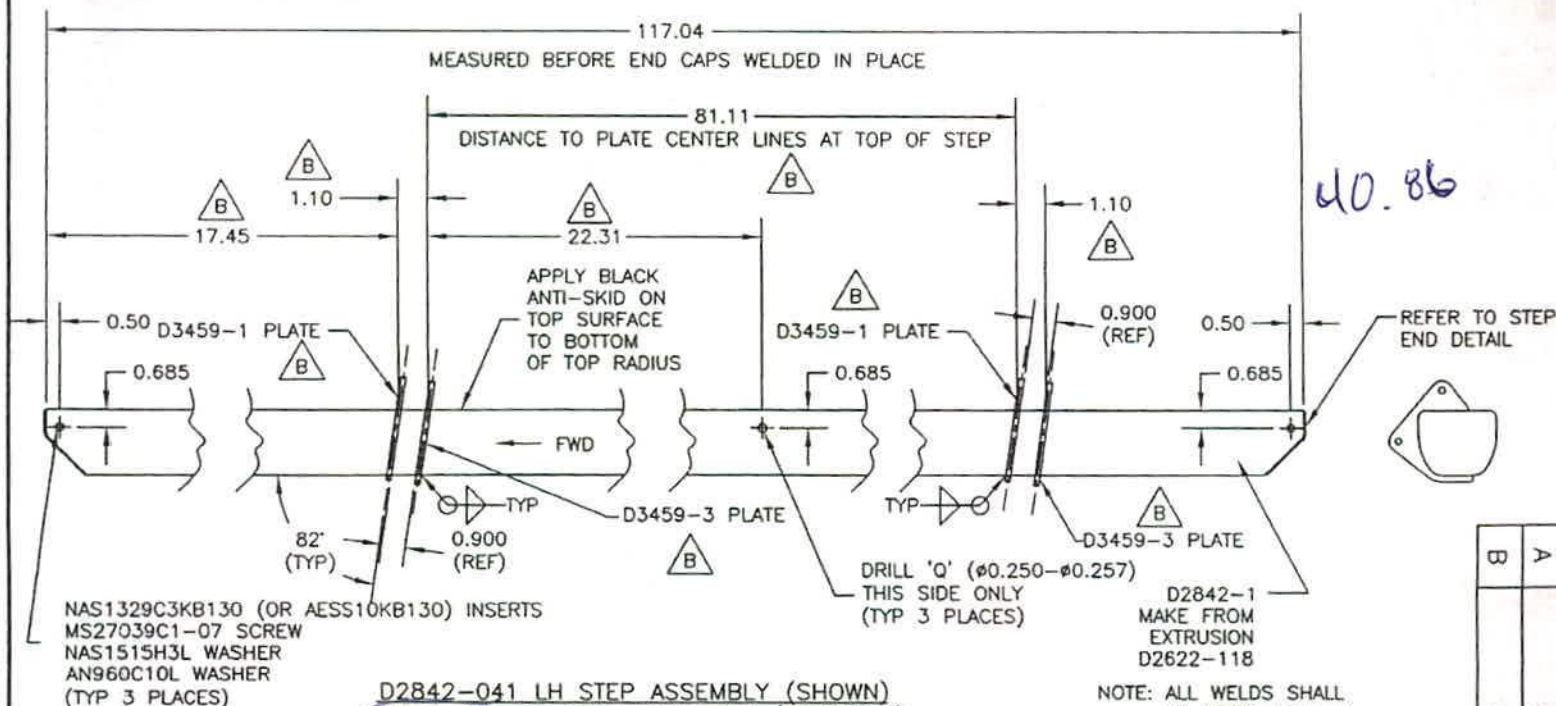
REV. B

SHEET 1 OF 1

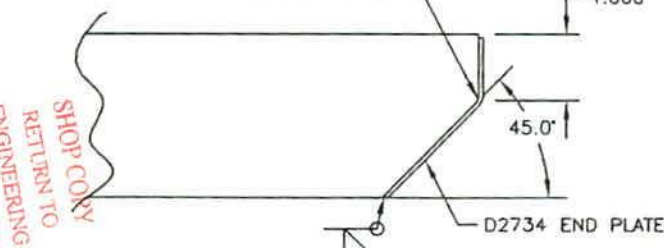
SCALE

NTS

DESIGN	DRAWN BY	DRAWING NO.	TITLE
KE	PH	D2842	206L/407 FLOAT STEP ASSEMBLY
CHECKED	APPROVED	DATE	SCALE
		05.09.23	NTS
A	98.10.13	NEW ISSUE	
B	05.09.23	RE-DESIGN, ADD D3459-1/-3	

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE**TYPICAL STEP END DETAIL**
NOT TO SCALE**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14